

Work Order ID 58976

May 20, 2010 1:13:01 PM



Page 1

Item ID: D3098-041

Accept



Setup Start



Revision ID:

Item Name: Relay Assembly

Stop



Start Date: 5/20/10 Start Qty: 1.00



Cust Item ID:

Required Date: 6/25/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3098

Rev A1

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

Dwg Rev: A1

Prog Rev: A1

2-Deburr if necessary

6061.050

1310-5-07

(2)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

1310-5-07

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

810105107

(2)

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr.	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
Small Fab	Memo	0.00							
Small Fab	C'sink holes as per dwg								
140	Bend as per dwg	0.00							
	NC BRAKE								
Brake NC	Memo	0.00							
Brake NC									
150	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

EP 10/05/31 (2)

SB 10/05/31

(2)

S 10/05/31

(42)

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 58976

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Item ID: D3098-041

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Setup Start



Revision ID:

Stop



Item Name: Relay Assembly

Start Date: 5/20/10 Start Qty: 1.00



Cust Item ID:

Required Date: 6/25/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 HandFinish	Chemical Conversion Coat per QSI005 4.1	0.00				<i>ml</i>	<i>10</i>	<i>05</i>	<i>31 (2)</i>
Hand Finishing	Memo	0.00							
170 Powdercoat	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 <i>1112588</i>	0.00	<i>=> 10106101</i>			<i>2</i>	<i>9</i>		
Powder Coating	Memo Start Time: <i>8:00 AM</i> Oven Temperature: <i>320 °F</i> Finish Time: <i>8:30 AM</i>	0.00							
180 QC	QC3- Inspect Part Finish	0.00							
Quality Control	Memo	0.00				<i>2</i>		<i>BR 10-6-1</i>	

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Work Order ID 58976

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Item ID: D3098-041

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Setup Start



Revision ID:

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Item Name: Relay Assembly

Start Date: 5/20/10 Start Qty: 1.00



Cust Item ID:

Required Date: 6/25/10 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190		0.00							
Small Fab	Memo	0.00							
Small Fab	Install hardware as per dwg								
200	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									
390	Identify as per dwg & Stock Location: <u>033</u>	0.00							
Packaging	Memo	0.00							
Packaging									

install relay *[Signature]* 10-06-30

S. 0606130

[Signature]

Packaging ① + 1 B. Product

PTD

W/O: 58976		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
12/06/20	390	Stock 1 x D3098-1 B/N 58976		SD		12-06-20	10/06/20

Part No: D3098-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 58976

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Item ID: D3098-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Relay Assembly

Start Date: 5/20/10 Start Qty: 1.00



Cust Item ID:

Required Date: 6/25/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

400

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/07/01 *AD**MF*

10-6-30

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 58976

Parent Item: D3098-041

Parent Item Name: Relay Assembly

Start Date: 5/20/10

Required Date: 6/25/10

Comments: IPP Rev:A as per dwg revA1 DD 10.05.19 verf:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	---------------	----------------	--------

M6061T6S.050

Purchased

No

100

sf

72.0000

1

15



6061-T6 .050 Sheet

8105-27

Location

Loc Qty

Loc Code

MAT21

72

110791

5

113216

64

17349

3

M83521/6-021M

Purchased

No

190

Each

0.0000

1

110791

②



Relay

MS20426AD34

Purchased

No

190

Each

6,716.000

4



RIVET

Location

Loc Qty

Loc Code

ST316

6716

104374

2716

110398

4000

MS20470AD34

Purchased

No

190

Each

11,441.00

3



Rivet, Universal Head

Location

Loc Qty

Loc Code

ST319

11441

111477

8332

15541

3109

M16941 ③

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 58976



Parent Item: D3098-041



Parent Item Name: Relay Assembly

Start Date: 5/20/10

Required Date: 6/25/10

Comments: IPP Rev:A as per dwg revA1 DD 10.05.19 verf:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	---------------	----------------	--------

MS21059L06

Purchased

No

190

Each

58.0000

2



Nutplate

EP 10/06/30

Location

Loc Qty

Loc Code

ST301

58

112255

58

2

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Shop Packet Print

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W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

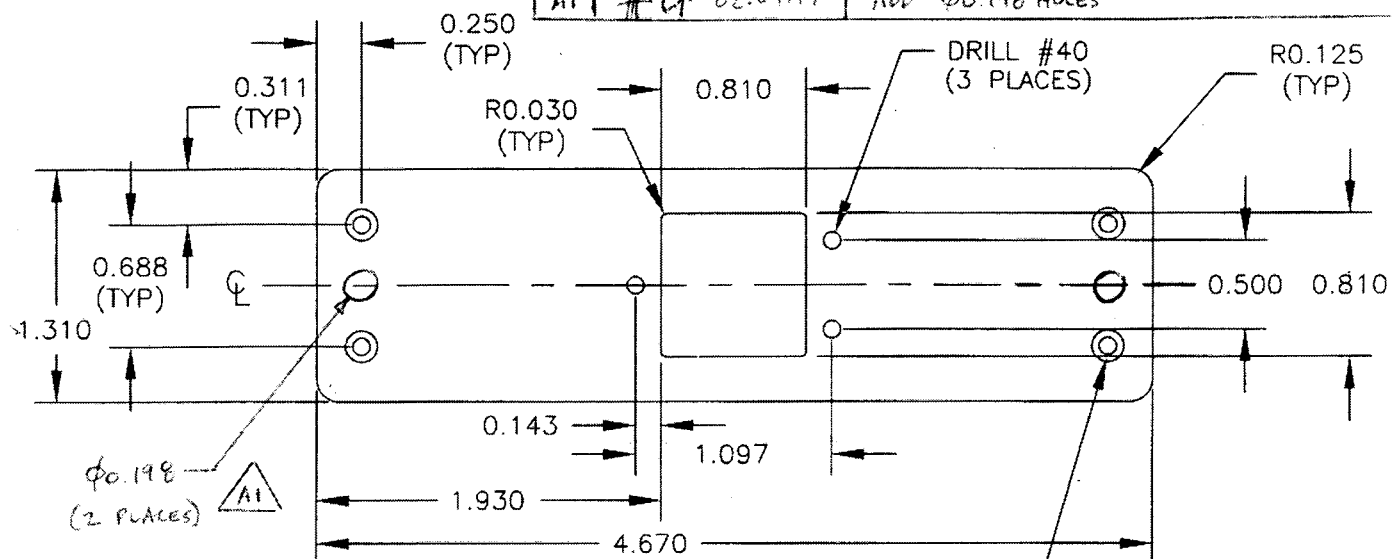
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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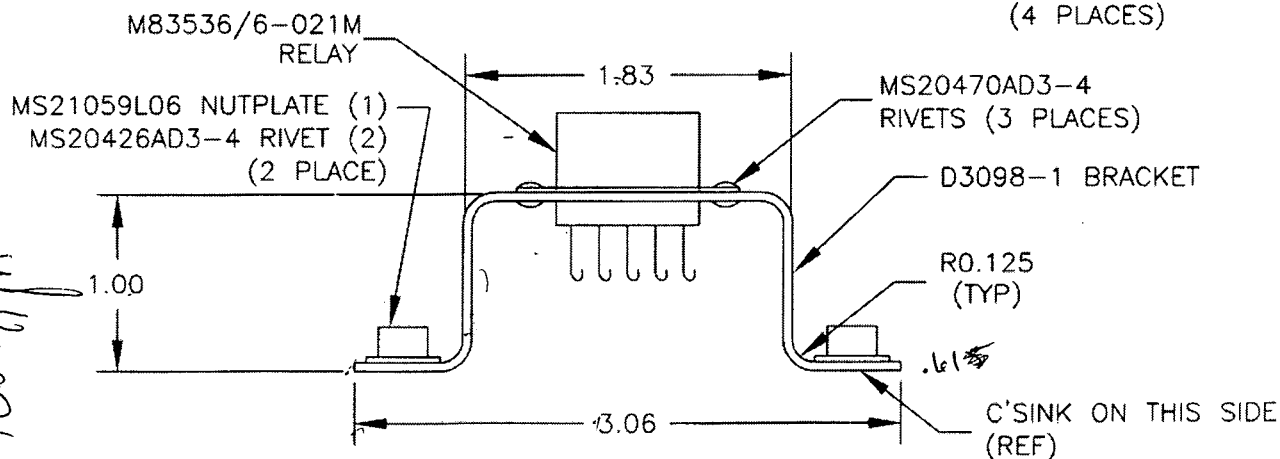
NOTE: Date & initial all entries



DESIGN A	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3098	REV. A SHEET 1 OF 1
DATE 02.03.20		TITLE RELAY ASSEMBLY	SCALE 1:1
A	02.03.20	NEW ISSUE	
A1	LP 02.04.17	ADD $\phi 0.148$ HOLES	



D3098-1 FLAT PATTERN



D3098-1 BEND DETAIL /
D3098-041 RELAY ASSEMBLY

D3098-1 NOTES

- 1) MATERIAL: 6061-T6 (QQ-A-250/11), 0.050 THICK
or 2024-T3 (QQ-A-250/4), 0.050 THICK
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTES
- 5) ALL DIMENSIONS ARE IN INCHES

RELEASED
02.03.22

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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